

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029151**Date Inspected:** 20-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL

CWI Name:	Robert Zimny		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** SAS Tower Elevator**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Fritz Belford was at the USA Hoist shop in Crest Hill, Illinois between the times noted above in order to monitor Quality Control functions and the in process work being performed by USA Hoist personnel. The following items were observed:

Manolo Luna (B):

Welder was observed machine cutting 6" x 6" x .375" tubular steel (Heat#0168580) for the elevator tower. At the end of the shift approximately 7 tubes had been cut using a band saw yielding 14 tubes total cut to length specified. Cutting will continue on the following shift.

Genaro Ulloa (D):

Welder was observed fitting and tack welding the middle hinge to the door and door frame assembly for door number 6 and adjusting the Door Safety Interlock mechanism until the lock engagement was satisfactory. Afterwards the welder proceeded to drill the bolt holes onto the top rail of door number 6 for the door closer. After drilling the four (4) 3/16" diameter bolt holes on the top rail the welder then tapped them with 1/4"-20 UNC. Upon completion of tapping the bolts holes the welder Ulloa then installed the Norton Rigid Door Closer Assembly. The welder was noted using gas shielded FCAW-G with 1.1mm E71T-1C Familiarc DW-50 wire electrode implementing USA Hoist Welding Procedure Specification FCAW3210. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 35 CFH. During the shift, the welding parameters were measured 26 volts and 196 amperes which deemed in compliance to the project requirements.

Matt Wasigi (A):

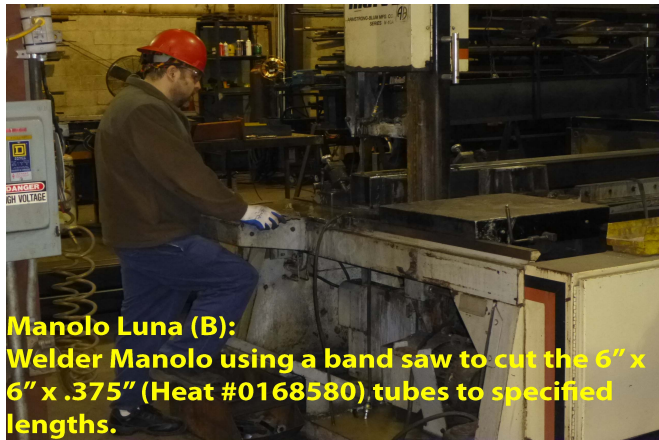
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Welder was observed trial fitting by installing the steel wire mesh (.75" x .75" x .135" Wire with Plain Steel C-Channel Frames: 1" Wide x 16 Ga. with 5/16" – 18 Hex Nuts welded to inside of frame) from Flynn & Enslow Inc. for door number 3 by drilling holes for the M8 x 25MM LG, FHCS bolts at locations corresponding to the M8 HEX nuts welded to the door wire mesh frame assembly. (Ref. Dwg. 914926)

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents



Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

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Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
